

**WHAT IS CLAIMED IS:**

1. A homogeneous, thermoreversible gel film comprising a film forming amount of low viscosity guar gum and optionally at least one of a plasticizer, a second film former, a bulking agent and a pH controlling agent.
2. The gel film of claim 1, wherein said second film former is at least one of a starch, starch derivative, starch hydrozylate, cellulose gum, lambda carrageenan, kappa carrageenan, kappa-2 carrageenan, iota carrageenan, polymannan gums, alginates, propylene glycol alginate, pullulan, gellan, dextran, pectin, an alkyl cellulose ether or a modified alkyl cellulose ether and said plasticizer is at least one polyol.
3. The film of claim 1, wherein said low viscosity guar gum is present in an amount of at least 0.25% by weight of the gel film.
4. The film of claim 1, wherein said low viscosity guar gum is present in an amount of 0.25% to 25% by weight of the gel film.
5. The film of claim 1, wherein said low viscosity guar gum is present in an amount of at least 10% of the total amount of second film formers in the gel film.
6. The film of claim 1, wherein said low viscosity guar gum is present in an amount of at least 40% of the total amount of second film formers in the gel film.

7. The film of claim 1, wherein said low viscosity guar gum is present in an amount of at least 60% of the total amount of second film formers in the gel film.
8. The film of claim 1, wherein said low viscosity guar gum is present in an amount of at least 80% of the total amount of second film formers in the gel film.
9. The film of claim 1 having a break force of at least 2,500 grams.
10. The film of claim 1 having a break force of at least 4,000 grams.
11. The film of claim 1 having a break force of at least 5,000 grams.
12. The film of claim 1 having a break force of at least 6,000 grams.
13. The film of claim 1 having a solids content of at least 50% by weight of the gel film.
14. The film of claim 1 having a solids content of at least 60% by weight of the gel film.
15. The film of claim 1 having a solids content of at least 70% by weight of the gel film.

16. The film of claim 1 having a solids content of at least 80% by weight of the gel film.
17. The film of claim 1 having a solids content of at least 90% by weight of the gel film.
18. The film of claim 1, wherein said low viscosity guar gum has a viscosity of less than 8,000 mPas.
19. Soft capsules comprising capsule walls and an encapsulated substance wherein said capsule walls comprise the films of claims 1-18.
20. The soft capsule of claim 19, wherein the capsule wall has a solids content of at least 50%.
21. The soft capsule of claim 19, wherein said encapsulated substance is at least one member selected from the group consisting of pharmaceuticals, vitamins, nutritional supplements, paintballs, pigments, agriculturals, cosmetics, flavorant or food.
22. A process for making the gel films of claims 1-18, comprising the steps of:
  - (i) heating, hydrating, mixing, solubilizing, and, optionally, de-aerating a composition of said low viscosity guar gum and optionally at least one of said plasticizer,

said second film former, said bulking agent and said pH controlling agent in an apparatus capable of providing sufficient shear, temperature and residence time to form a homogeneous, molten composition, wherein said temperature is at or above the solubilization temperature of the molten mass; and

(ii) cooling said molten composition at or below its gelling temperature to form the gel film.

23. The process of claim 22, wherein said molten composition is fed directly into at least one of a mixer, pump or devolatilizer prior to cooling.

24. The process of claim 22, wherein said apparatus is a Ross mixer, Stephan processor, extruder, jet cooker or fluid mixing apparatus.

25. A process for making soft capsules of claim 19 containing the gel films of claims 1-18 comprising the steps of:

(i) heating, hydrating, mixing, solubilizing, and, optionally, de-aerating a composition of said low viscosity guar gum and optionally at least one of said plasticizer, said second film former, said bulking agent and said pH controlling agent in an apparatus capable of providing sufficient shear, temperature and residence time to form a homogeneous, molten composition, wherein said temperature is at or above the solubilizing temperature of the molten mass; and

(ii) making soft capsules directly from said molten composition or allowing said molten composition to cool to its gelling temperature or below and thereafter making soft capsules therefrom .

26. The process of claim 25, wherein said apparatus is a Ross mixer, Stephan processor, extruder, jet cooker or fluid mixing apparatus.

27. The process of claim 25, wherein said molten composition is fed directly into at least one of a mixer, pump or devolatilizer prior to making soft capsules.

28. A solid form comprising a fill material encapsulated by the homogeneous, thermoreversible gel film of claims 1-19.

29. The solid form of claim 28, wherein said fill material is a powder, tablet, caplet, microcapsule or capsule.

30. The solid form of claim 28, wherein said solid form is a hard capsule.

31. A homogeneous, thermoreversible gel film comprising a film forming amount of low viscosity polymannan gum and optionally at least one of a plasticizer, a second film former, a bulking agent and a pH controlling agent.

32. A process for making a gel film, comprising the steps of:

(i) heating, hydrating, mixing, solubilizing, and, optionally, de-aerating a composition of a low viscosity polymannan gum and optionally at least one of a plasticizer, a second film former, a bulking agent and a pH controlling agent in an apparatus capable of providing sufficient shear, temperature and residence time to form a homogeneous, molten composition, wherein said temperature is at or above the solubilization temperature of the molten mass; and

(ii) cooling said molten composition at or below its gelling temperature to form the gel film.

33. Soft capsules comprising capsule walls and an encapsulated substance, wherein said capsule walls comprise a homogeneous, thermoreversible gel film comprising a film forming amount of a low viscosity polymannan gum and optionally at least one of a plasticizer, a second film former, a bulking agent and a pH controlling agent.

34. A solid form comprising a fill material encapsulated by a homogeneous, thermoreversible gel film comprising a film forming amount of a low viscosity polymannan gum and optionally at least one of a plasticizer, a second film former, a bulking agent and a pH controlling agent.

35. A process for making soft capsules comprising the steps of:

(i) heating, hydrating, mixing, solubilizing, and, optionally, de-aerating a composition of a low viscosity polymannan gum and optionally at least one of a plasticizer, a second film former, a bulking agent and a pH controlling agent in an

apparatus capable of providing sufficient shear, temperature and residence time to form a homogeneous, molten composition, wherein said temperature is at or above the solubilizing temperature of the molten mass; and

(ii) making soft capsules directly from said molten composition or allowing said molten composition to cool to its gelling temperature or below and thereafter making soft capsules therefrom.